Work Orde		839			Page 1							
Revision ID:	D412-705-01		A	Accept	*N900	040	100)* ፡	Setup	Start Stop	IVI	S1* S2*
Start Date: Required Date: Reference:	10/01/12 10/12/12	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item ID: Customer:							
Approvals:	Process Plan	n: _ <i>ML5</i>	Date: 12-10-0\	Tooling:	D	···]	Run	Start	*N	R1*	
	QC:		Date:	SPC (Y/N):	D				Stop	*N	R2*	
Sequence ID/ Work Center ID	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr										
D3255	Rev	В			71							
1 \\ \n^ \\ DC \\ Document Control		DOCUMENT CONTROL Memo Photocopy bl	L luefile & type labels per PPP	0.00 0.00 0.00 0.00 0.00 0.00 0.00) γ7 (ω(3 (CHG001			4	40,	Me	J 12	2-10-30 9)
110 *110* Packaging		Pick Kit		0.00				/] (4)	<u>/</u> /3	<u>ه</u> (-	2
Packaging			·	OAG					<i>'</i>			
*120 *120* QC Quality Control		QC4- 100% Inspect kits f	or completeness	0.00	1/(01)			0	- - 			

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE															
		•							_		QA Closed:	Date:	•		
Nork Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part I	No.					Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			4	Water Jet J. Eng. Coor. e/Packaging	Engineering Quality Other		
NCR f	NCR No.					Work Order Update						Supplier			
Root					Descr	ription of work order update		Initial	Ac	tion	Sign &				
Cause		Date Step Qty or Non-conformance				Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector			
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Inapproved												<u>.</u>			
							FAUL	T CATE	GORY						
Landi	ng (Gear				General		_			_		_		
		Bending				Bend		Grain			Ovalized		Pressure/Forced		
		Centre No	ot Concer	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure		
		Cracks				Broken/Damaged		Inspect	on Incomplete		Part Incorred	ct	Weld		
		Crushed/0	Crimped.		Γ	Burrs		Instruct	ions Incomplete	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled		
		Cuffs				Contamination		Mainte	enance		Part Moved		_		
		Heat Trea	t			Countersink		Mislabe	eled		Positioned V	Vrong			
	Inspection Strip in Tube Cut Too Short						Г	Misread	d		Power Loss/	Surge	Other		
	Ripples in Bend Drill Holes							Offset		<u> </u>	_	_			
	Torque Waves in Extrusion Drawing							Out of	Calibration						
	Turning Sequence Finish							Out of Sequence							
	Wave/Twist in Tube Folio							1	Dimensions						

DQA: Date:

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Work Ord October-01-12				*90839*									
Item ID: Revision ID:	D412-705-	017		Accept	*N900	040	110	N *	Setup	Start	*N	S1*	
Item Name:	N1 Gearbox	Access Panel								Stop	*N	S2*	
Start Date: Required Date Reference:	10/01/12 e: 10/12/12	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item 1 Customer:	Cust Item ID: Customer:							
Approvals:	Process P	lan:	Date:	Tooling:	D		Run	Start	*N	R1*			
	QC:		Date:	SPC (Y/N):	Date:					Stop	*N	R2*	
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
130		Packaging						(20)			12/	12/15/01	
Packaging		Memo		0.00				1-20				1013/39	
Packaging		Identify and 017Location	pack for shipping as per : PPP Re									'	
140		QC21- Final Inspection -	Work Order Release	0.00						,) /	1'. 210	
140 QC Quality Control		Memo		0.00					- · - <u>-</u>		160/	31 4	

W12-10-31

									DQA:	Date:	
NCR: Yes	s / No				WORK ORDER NON-C	ONFORM	MANCE / UP		QA Closed:	Date:	•
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	PROCESS	*
Part No					Rework Scrap Use-as-is Work Order Update]	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling]										
Operator		1									
Material]										
ietup]										
Other 1	_]			٠.							
Process	_	1						•			
Supplier								,			

FAULT CATEGORY Landing Gear General Ovalized Pressure/Forced Bend Grain Bending Over/Under tolerance Temperature/Cure BOM/Route Centre Not Concentric to O/S Hardware Broken/Damaged Inspection Incomplete Weld Cracks Part incorrect Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Maintenance Cuffs Contamination Part Moved Mislabeled Positioned Wrong Countersink Heat Treat Other Inspection Strip in Tube Misread Power Loss/Surge Cut Too Short Drill Holes Offset Ripples in Bend Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence

Outside Dimensions

Wave/Twist in Tube

Folio

Training Unapproved

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Picklist Print

October-01-12 7:43:13 AM

-Work Order ID:

90839

Parent Item:

D412-705-017

Parent Item Name:

N1 Gearbox Access Panel

Start Date: 10/01/12

Required Date: 10/12/12

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:C Removed Manufacturing 06-08-02 JLM IPP Rev:D ECN 1052 07-11-06 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C3A		Purchased	No			120	Each	294.0000	30	60	12216	, 1 /	
Bolt									-	-	12214	1.0	در
				Location		Loc Qty	Le	oc Code					•
				GA		62							
					352	62							
				ST350		232							
					187	1			75				
D3255-041			NI-	122	141	231			12				
Access Panel Assembly		Manufactured	No			120	Each	3.0000	1	2 L	86/0	8_/	
				Location		Loc Qty	Lo	oc Code					
				ST176		3							
				861	08	3							d
D3255-042 Access Panel Assembly		Manufactured	No			120	Each	2.0000	1	2	90404		
				Location		Loc Oty	Lo	oc Code			/ /	\mathcal{C}	
				ST176		2							
				788		1						_	•
MS20427M3-3				861	02	1							
MS20427M3-3 VRivet		Purchased	No			120	Each	229.0000	36	72		// /3	10/30
				Location		Loc Qty	Lo	oc Code				/	
				GA		214							
				121	114	214			12	1114			
				ST318		3			~				
				120	930	3							
				ST335		12			-				
				123	021	12			-				

									DQA:	Date:			
NCR: Yes	/ No				WORK ORDER NON-C	ONFORM	MANCE / UF		QA Closed:	Date:			
Mark Ordan					DISPOSITION			AGAINST DEI	PARTMENT	PROCESS	*		
Nork Order:					Rework		Skid-tube Crosstube			Water Jet	Engineering		
Part No.					Scrap	4 1	Machining	Small Fab		d. Eng. Coor.	Quality		
NCR No.	CR No.				Use-as-is Work Order Update	Thern	noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other		
Root				Descri	ption of work order update	Initial	А	ction	Sign &				
Cause	Date	Step	Qty	,	or Non-conformance	Chief Eng	Des	cription	Date	Verification	QC Inspector		
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)ther	1	}											
rocess	1]									
upplier	1												
raining	1												

FAULT CATEGORY

Grain

Hardware

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

Ovalized

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Over/Under tolerance

Pressure/Forced

Weld

Other

Temperature/Cure

Wrong Stock Pulled

General

Bend

Burrs

BOM/Route

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Broken/Damaged

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Unapproved

Landing Gear

Bending

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

Picklist Print

October-01-12 7:43:14 AM

Page 2

-Work Order ID:	90839										
Y Parent Item:	D412-705-017						Start 1	Date: 10/01/12		Required Date:	10/12/12
Parent Item Name:	N1 Gearbox Access Panel						Start	Qty: 2.00		Required Qty:	
MS21060-L3K Nut Plate	Purcha	sed No			120	Each	139.0000	18	36	123 250	(d) 50)
<i>y</i> *			Location		Loc Oty		Loc Code			•	•
			316		42						
			1	22814	42						
			ST303		95						
			1	20142	95						
			ST319		2						W
			1	22141	2						
S MS9321-09 Washer	Purchas	sed No			120	Each	510.0000	30	60	T /3	12/130 2
			Location		Loc Qty		Loc Code			(
			ST296		510						
			1	19546	50		•				
				20142	2						
				21524	1						
			1	22141	457			1221	41		

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Work Orde	or.					DISPOSITION				AGAINST	DE	PARTMENT/	PROCESS		`
WOIR Old	-'' —					Rework	1		Skid-tube	Crosstube			Water Jet	П	Engineering
Part N	۱o.					Scrap	Machining Small Fab Prod. Eng. Coor.						Quality		
	_	-				Use-as-is	-is Thermoforming Finishing Rec/Store/Packaging							Other	
NCR N	۸o					Work Order Update]		Large Fab	rge Fab Composite Supplier					
Root					Descri	ption of work order update		nitial	Ac	tion		Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
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Process															
Supplier														ļ	
Training												•			
Unapproved															
							AUL	T CATE	GORY						
Landi	ng Ge	ar				General		-			_	7			1
Bending				Bend		Grain			L	Ovalized			Pressure/Forced		
Centre Not Concentric to O/S					o/s	BOM/Route		Hardwa	ire		L	Over/Under tolerance			Temperature/Cure
	Cracks					Broken/Damaged ·	Inspection Incomplete			L	Part Incorrect			Weld	
	Crushed/Crimped.					Burrs		Instructions Incomplete/Unclear				Part Lost/Missing			Wrong Stock Pulled

Maintenance

Out of Calibration Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Part Moved

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish Folio

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